Page 1

Tuesday, May 24, 2011 10:05:02 AM Item ID: D3371-1 Accept Setup Start Revision ID: Stop Item Name: Pedal Lock Base Start Qty: 4.00 **Start Date:** 5/24/2011 **Cust Item ID:** Required Date: 6/10/2011 Req'd Oty: 4.00 **Customer:** Reference: Run · Start Date: 11-05-24 Tooling: Process Plan: Approvals: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Otv Number Stamp Draw Nbr **Revision Nbr** Rev B D3371 0.00 **BAND SAW** m/ 11/07/07 Bandsaw 0.00 Memo Jeaspa Bandsaw Cut blank: 2.00" x 2.25" x 7.370" long 110 0.00 HAAS CNC VERTICAL MACHINING #1 HAAS 1 0.00 Memo HAAS CNC vertical machine #1 Machine D3371-1 as per Folio FA486 and Dwg D3371□Deburr□Finish 8-32 thread by hand [Identify as D3371-1 120 QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 Memo Quality Control

W/O:			W	ORK ORDER	R CHANGES	,				·
DATE	STEP	PROCE	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				4/4	\$.07.18					
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Item ID:

D3371-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Pedal Lock Base

Required Date: 6/10/2011

Start Date:

5/24/2011

QC:

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date:

Date: _____

Tooling: SPC (Y/N):

Date: Date:

Run Start

Stop



Sequence ID/

Work Center ID

130

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ **Run Hours**

0.00 JL 11-07-18

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

0.00

0.00

4 / Mulozlia

145

Powdercoat

Fire Red(Ref:4.3.5.10) per QSI005 4.3

Finish Time: X

Memo

POWDER CO

0.00

0.00

4 & BL 11-7-19.

Powder Coating

W/O:			WC	ORK ORDER CHANG	FS				
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		esolution:							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC			ion B		cation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a Date		ion C	Chief Eng	QC Inspector
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		·							

170

QC

Quality Control

Page 3

Insp.

Tuesday, May 24, 2011 10:05:02 AM D3371-1 Item ID: Accept Setup Start **Revision ID:** Stop Item Name: Pedal Lock Base **Start Date:** 5/24/2011 Start Qty: 4.00 **Cust Item ID:** Required Date: 6/10/2011 **Reg'd Oty:** 4.00 **Customer:** Reference: Run Start Date: Tooling: Approvals: Process Plan: Date: Stop Date: _____ QC: SPC (Y/N): Date: Sequence ID/ Tool # Plan Operation Set Up/ Tool ID Reject Accept Reject Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 150 QC3- Inspect Part Finish 0.00 QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 6 160 0.00 SB 11/02/19 Packaging 0.00 Memo Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

11/20 A) MK 19

W/O:	· [WC	ORK ORDER CHANG	iES			,	
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:	Fault Cate	QA:					
		solution:	Disposition	n:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)			
DATE STEP		Description of NC Section A	ription of NC Section A Corrective Initial Action		tion B		ification	Approval Chief Eng	Approval QC Inspector
		OCCUON A	Chief Eng			te			QO moposto.
									-
							****		-

Picklist Print

Tuesday, May 24, 2011 10:04:54 AM

Work Order ID: 69897

Parent Item:

D3371-1

Parent Item Name: Pedal Lock Base



Start Date: 5/24/2011

Required Date: 6/10/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A□05.01.18□New issue□KJ/JLM□IPP RevB: add powdercoat DD

10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25		Purchased	No		100	f	0.0000	0.625	2.631579)		



6061-T6 Bar 2.00 x 2.25

4118072×2.64 and 11/07/07

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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						•					
Part No	•	PAR #: Fault Category: NC	R Yes	No DQ	۱.	Date:	<u></u>				

Disposition: _____ QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
<u> </u>		Description of NC		Corrective Action Section B		Verification	Approval	Approval	
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NOTE: Date & initial all entries

Resolution:

DART AEROSPACE LTD	Work Order:	19897
Description: Pedal Lock Base	Part Number:	D3371-1
Inspection Dwg: D3371 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

00° 2.25 1.650 1.648	+/-0.5° +/-0.030	Dimension	Accept	Reject	Inspection	Comments
2.25 1.650 1.648	+/-0.030		~		0 1	
1.650 1.648		0			Angle protr.	CNC-08
1.648		2.251	~		Vein	6A-01
	+/-0.010	1.653	~		5 (, 0
	+/-0.010	1.650	~		11	ν
0.700	+/-0.010	107.0	~		0-6	BO-AD
3.955	+/-0.010	3.955	~		Vern	GA-01
0.600	+/-0.010	0.602	~		H-6	31006
0.104	+/-0.010	0.110	~		Vern	6 A-01
0.305	+/-0.010	0.300	~		41	11
45°	+/-0.5°	450	1		Angle proto	CNC-08
0.672	+/-0.010	0.668	~		Vein	GA-01
Ø1.300	+/-0.010	91.299	\		11	17
1.450	+/-0.005	1.450	~)1	(1
7°	+/-0.5°	70	~		Any le prote	CNC-08
	4				0 1	
2.00	+/-0.030	1.999	✓		Vern	GA-01
1.125	+/-0.010	1,124	~		()	//
Ø1.125	+/-0.010	\$1.126	✓		11	d
R0.500	+/-0.010	RO,500	~		R-6	sef.
1.000	+/-0.010	0.999			Vern	GA-01
0.375	+/-0.010	0.374	~		11	11
Ø0.203	+0.005/-0.000	\$0.206	-		11	1) .
7.19	+/-0.030	7.186	/		VCIN	CNC-02
4.500	+/-0.010	4.499	✓ /		Vein	6A-01
0.500	+/-0.010	0.500	1		ft	1/

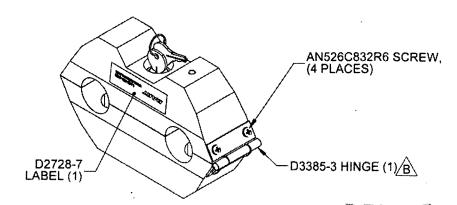
Measured by:	A. C.	Audited by:	シレ	Prototype Approval:	N/A
Date:	11/07/18	Date:	11-07-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.04.26	New Issue	KJ/JLM	1
В	05.05.25	Revised dimensions	KJ/JLM	
			171	

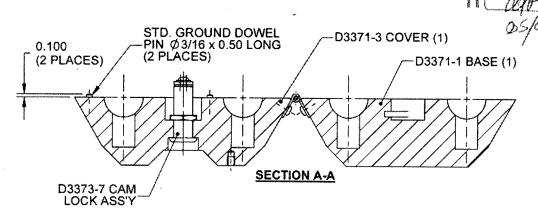
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NCR:		Wo	ORK OR	DER NON-CONF	ORMANCE	(NCR)		,		
DATE	STEP	Description of NC	Corrective Action			Sign & Verificat			Approval	Approval
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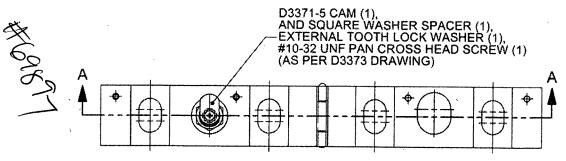


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DESIGN	45	DRAWNBY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	ED ‡	APPRO		DRAWING NO. D3371	REV. B SHEET 1 OF 4			
 DATE	05.0	03.22		PEDAL LOCK	SCALE 1:3			
Α	0	4.12.06		NEW ISSUE				
В	0	5.03.22		D3385-3 WAS D3385-1	·			



PEDAL LOCK SHOWN LOCKED WITH KEY





D3371-051 PEDAL LOCK ASSEMBLY

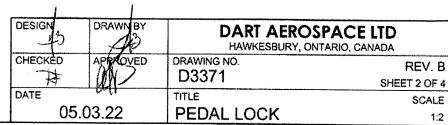
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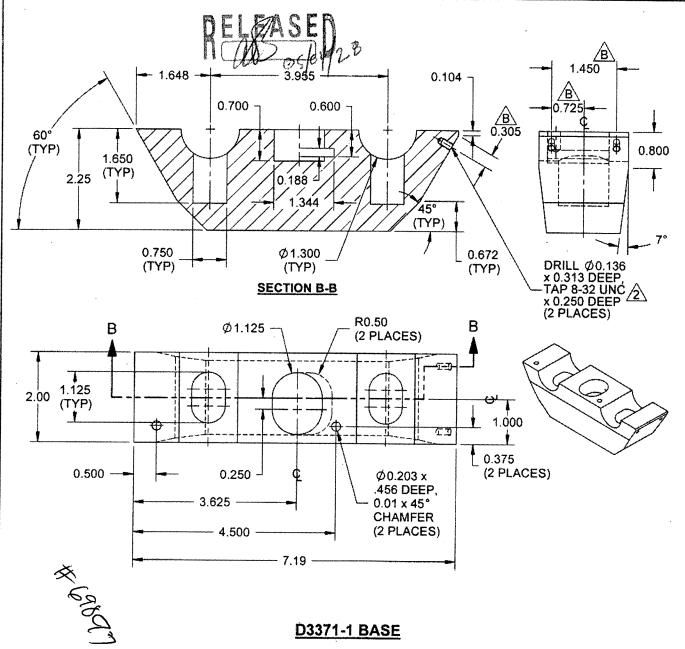
1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2) ALL DIMENSIONS ARE IN INCHES

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W/O:			WC	ORK ORDER CH	ANGES	. ,				
DATE	STEP	PROC	EDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B) 2) COVER INSIDE HOLES PRIOR PAINTING

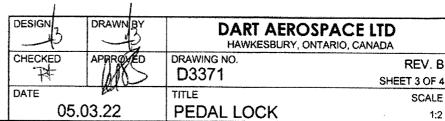
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

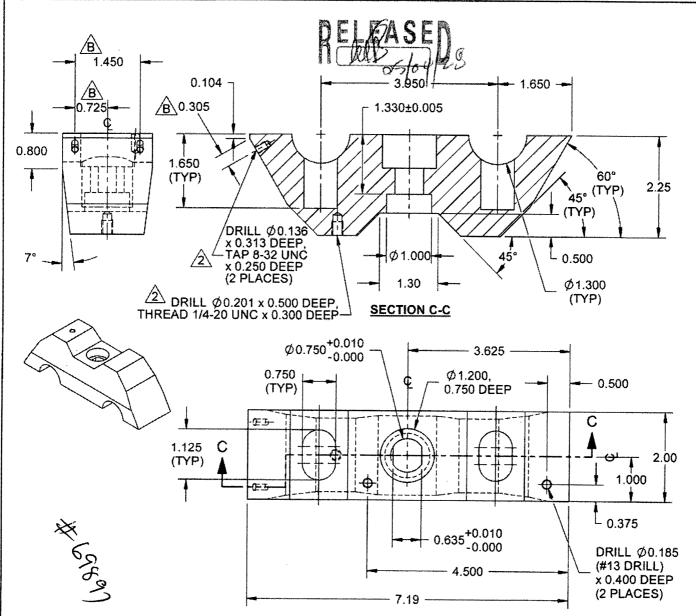
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D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
 (REF. DART SPEC. M6061T6B)
 2) COVER INSIDE HOLES PRIOR PAINTING
 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd	D	art	Aer	osp	oace	Ltd
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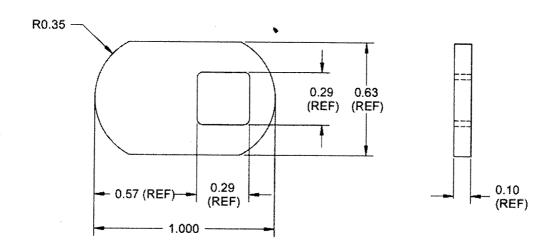
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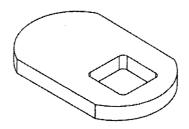


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DATE	-1/AX	TITLE	SHEET 4 OF 4 SCALE		
05	.03.22	PEDAL LOCK	2:1		



SPECIFICATION CONTROL DRAWING







D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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